

Date: Thursday, 1/17/2008 3:30:11 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CUFF
Job Number : 36835	
Estimate Number : 13023	
P.O. Number :	Part Number : D36601
This Issue : 1/17/2008 S.O. No. :	Drawing Number : D3660 UNDER REV <i>LEVA U/R</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1	Drawing Revision : <i>U/R # Rev A U/R</i>
Previous Run : 36651	Material :
Written By : <i>[Signature]</i>	Due Date : 2/5/2008 Qty: 10 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : est rev A new issue 07.09.19 EC verified by: JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6009129P	Crosstube Material
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Comment: Qty.: 0.3460 Each(s)/Unit Total : 3.4598 Each(s)

D6009-180 D6009-129 X-TUBE MATERIAL
 batch: *B25667*

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

1-Turn as per folio FA 708 & DWG D3660,
 FOLIO REV: *A*
 DWG REV: *A*

2-Deburr as required

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

MJ 08-01-28

(X11)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/01/29

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUFF

Job Number: 36835

Part Number: D36601

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5/1/28

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *D.P.*

8/1/28 SQ (IX)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(11)

Comment: FINAL INSPECTION/W/O RELEASE

12/28/01/29

Job Completion



u 28-01-29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

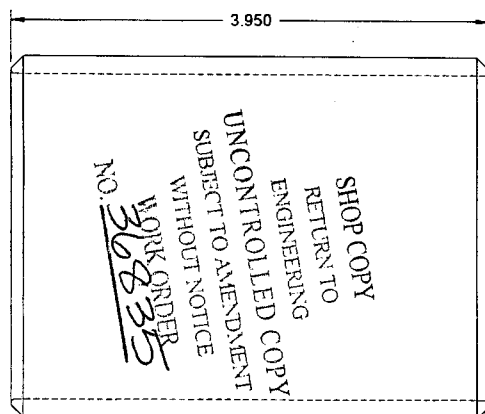
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

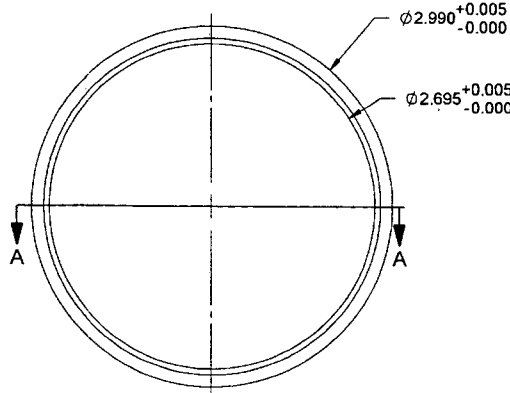
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SECTION A-A



R0.032
(TYP INSIDE EDGES)



CHAMFER 0.100 x 45°
(TYP OUTSIDE EDGES)

D3660-1 CUFF

NOTES:

- 1) MATERIAL: 7075-T6/T6511 SEAMLESS TUBE (WWW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11)
(CAN MAKE FROM D6006, D6008, OR D6009)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.52 lbs

RELEASED
07 09 24

REV.	DESCRIPTION	CP	DATE
A	New Issue	BY	07.07.07
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3660	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		CUFF	1:1
DATE	07.07.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

